

## Zen Magnetic Fountain Pen Kits

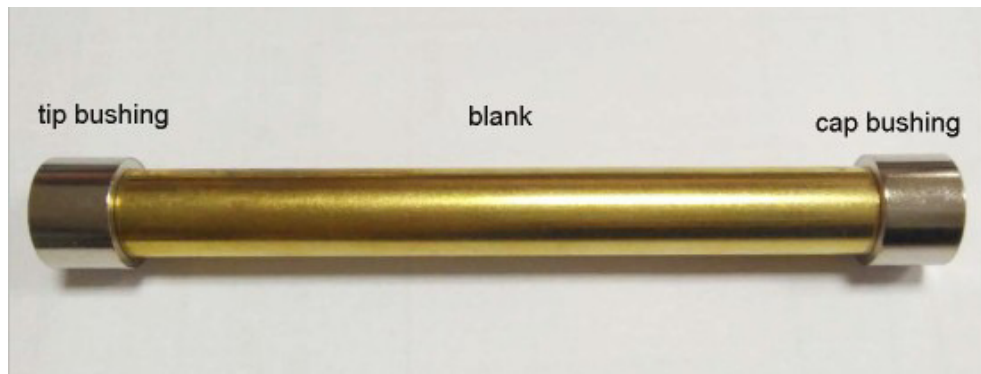
### Required Accessories

- 7mm pen mandrel
- 2-piece Zen bushing set
- Drill Bit 10.5 mm
- Universal barrel trimmer
- Glue (Thick CA or Epoxy)



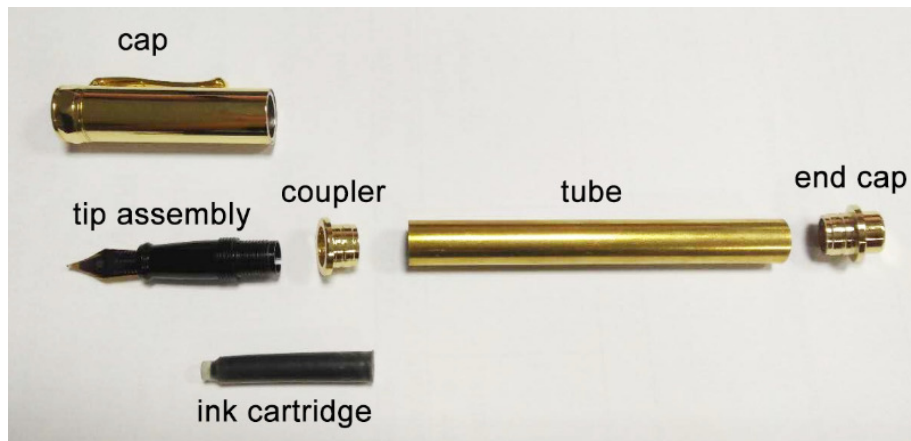
### Preparing the Blank

- Cut one pen blank to the length of the brass tube (add 1/16" for trimming).
- Drill a 10.5mm hole lengthwise through the blank.
- Spread the glue over the tube. Insert the tube into the blank with a twisting motion to spread the glue evenly inside. Center the tube lengthwise in the blank.
- When the glue dries, Square the end of blank. Use a Barrel trimmer or a universal pen blank squaring jig with a power disc sander. Take the wood down to the brass tube. Do not trim beyond the length of the tube since this may interfere with operation of the mechanism and assembly. Use the barrel trimmer shaft to clean the inside of the tube.



### Turning the Blank

- Mount the bushings and blank according to the diagram above.
- Thread on the knurled nut and hand tighten to hold all components in place.
- Slide the tailstock up snugly against the mandrel shaft inserting the live center point into the mandrel dimple, lock in place.
- Hand tighten the quill adjustment to firm up the mandrel. (DO NOT overtighten, it could damage the mandrel.
- Using sharp tools, turn the blank down close to the bushing diameter. Turn the barrel (straight or to a profile of your choice)
- Sand the blank down to be flush with the bushings gradually increasing the sandpaper grits.
- Finish the barrel with your choice of polish. Allow sufficient time for the polish to cure.



### **Assembly**

Assembly NOTE: Line up the components according to the above picture.

- Place the end cap into the end of the tube
- Press the coupler into another end of the tube.
- Attach the ink cartridge to the back of the fountain nib, then thread the fountain nib into the nib coupler.